

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 74.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022645**Date Inspected:** 29-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Goodwin Steel, UK**Location:** Trentham, UK

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	Cable band				

Summary of Items Observed:

The following report is based on METS observations at Trentham UK on this date:

The QA Inspector observed set up and welding of Casting GG29439-1, Drawing Number 5540-B10-1-M. The welding was being performed by Mr. M. Edwards. Mr. Edwards was using WPS 04-0120F4G Issue 6. The welding was being performed at 26.9 volts and 185 amps. The heat input and the travel speed were being monitored. The filler metal was AWS A5.20 E71T-1M. The shielding gas was BOC Argon-shield Heavy. These are within the allowable range of the WPS. Welding was being performed in the 1G position.

The QA inspector did periodically observed dressing of the cable band for West Panel Point 40 consisting of castings GG29444-1, and GG29445-1. This is a B13 type 2 cable band. Rough edges, sharp corners and radius are being ground to finish condition. The dressing is being performed by Goodwin International Personnel.

The QA Inspector observed Goodwin International QC personnel preparing the hand rope and messenger anchors for final inspection by removing all sharp edges. The final visual inspection was performed by Goodwin QC personnel. Small areas on the flame cut edges were identified for further grinding to achieve a surface finish of 1000μ inches.

The QA Inspector did periodically observe casting GG29440-3, drawing 5540-B10-2-M at the Scheiss Froriep vertical machining center for machining of areas of the bore that had been repaired by welding. Only the areas that were weld repaired were being machined. The machining has not been completed.

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Summary of Conversations:

Relevant conversations are documented above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Riegler,Randy	Quality Assurance Inspector
Reviewed By:	Edmondson,Fred	QA Reviewer
